

Work Order ID 68009

Tuesday, April 05, 2011 10:53:18 AM

Page 1

Item ID: D4323-24

Accept

Revision ID: PRELIM

Item Name: Access Panel, RH

Start Date: 4/5/2011 Start Qty: 1.00

Required Date: 4/5/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: *mf*

Date: *11-04-05* Tooling:

QC:

Date:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Draw Nbr

Revision Nbr

D4323

PA7 PA83

100



HandThermo

Hand Finishing Thermoforming

Memo

I-Cut Sheet to required Blank size

0.00

0.00

105



HandThermo

Hand Finishing Thermoforming

Dry Material

Memo

Dry Sheet as per QS1022 Kydex

0.00

0.00

Temp:

Time IN:

Time OUT:

140° 150°
6:00 PM 11/04/04
7:00 11/04/05

Cust Item ID:

Customer:

PRELIMINARY ISSUE



Setup Start

Stop



Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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BB
11/04/05

BB
11/04/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Thermoform

Thermoforming Machine

Memo

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA108 using tool DT9733

Dwg Rev: PASFolio Rev: A

0.00

120

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

Visually inspect part for proper formation and texture

0.00

130

0.00



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

BB
11/04/05

BB
11/04/05

Ph
11/04/05

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 68009

Tuesday, April 05, 2011 10:53:18 AM



Page 3

Item ID: D4323-24

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Setup Start



Revision ID: PRELIM

Item Name: Access Panel, RH

Stop



Start Date: 4/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

Wh
11/04/05

150

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

Complete FAI document

BB 11/04/05

160

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

- inspector to PAZ
Don only
Sulox102

(40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

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Page 4

Item ID: D4323-24

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Setup Start



Revision ID: PRELIM

Item Name: Access Panel, RH

Stop



Start Date: 4/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Identify as per dwg & Stock Location: *REAL*

0.00



Packaging

Memo

0.00

Packaging

11/4/6 ①

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*RD
2370*

POSITIVE RECALL

EFFECTIVE *11/04/05*

AUTH *LC*

RELEASED

DATE

MF 11-04-05

*SCRAPPED PER
DAN CAMPBELL*

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, April 05, 2011 10:53:15 AM

Page 1

Work Order ID: 68009

Parent Item: D4323-24

Parent Item Name: Access Panel, RH



Start Date: 4/5/2011

Required Date: 4/5/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA New Issue 11-03-01 DL verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	787.2912	3.46875	3.46875			



6185 KYDEX .080"



Location

therm

116576

Loc Qty

787.2912

787.2912

Loc Code

1

11/04/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	68007
Description: ACCESS PANEL 3A.		Part Number:	04323-24
Inspection Dwg: 4323 Rev: PA8		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <u>JB</u>	Date: _____
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.58"	±0.30"	10.55	✓		1H 03	
18.00"	±0.30"	17.95	✓		1H-05	
9.78"	±0.30"	9.78	✓		1H 03	

Measured by: <u>JB</u>	Date: <u>4/04/05</u>
Audited by: <u>J & M PA 7 Day</u>	Date: <u>11/04/06</u>
Preliminary Approval: _____	Date: _____

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14

